



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RUSH

D2652
Job Sheet 167275



11/1

Part No: D2652

Job Qty: 300 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 10/30/17

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	300 Ea		10/27/17	0.00	0.00	Start Up Machining		
100	Hardinge	300 pcs		10/30/17	0.00	11.04	Hardinge		
120	QC	300 pcs		10/30/17	0.00	0.00	QC8		<i>17-10-31</i>
130	Packaging	300 pcs		10/30/17	0.00	0.00	Packaging3		
140	QC21-SA	300 Ea		10/30/17	0.00	0.00	QC21		<i>MW 17-10-31</i>

Part Op
Descriptions: 100 - 1-TURN AS PER FOLIO FA252 & DWG D2652

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.500	17	70	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.600inches ± 0.010	0.610 0.590		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.305inches + 0.002 - 0.000	0.307 0.305		
4	Bushing	0.191inches + 0.005 - 0.001	0.196 0.190		
5	Bushing	0.500inches ± 0.010	0.510 0.490		
6	Bushing	0.030inches ± 0.010	0.040 0.020		
7	Bushing	20.000Degrees ± 0.010	20.010 19.990		
8	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010		

Plex 10/27/17 12:59 PM dart.lacelle.linda

M138346
68.5"

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description \	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval					
 S003343 Bushing PART NO: Revision: Operation: Quantity: Change No: D2652 Start up Operation 300 Mfg Date: 10/28/17 Job No: 167275							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verificat ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>	Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verificat ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; vertical-align: top;"> BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Grind ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>		Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Grind ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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Traveller Change Request

Part#: D2652

Job#: 167 275

Name Luc Perrier

Date 17-10-29

Workcenter Cobras Hardinge

Operation # 100

Issue:

Quality ☒

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: Tolerance on .305 Dimension is wrong
on checklist Should be $\varnothing.305 - .002 + .000$

Name _____

Date _____

Workcenter _____

Operation # _____

Issue:

Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Name _____

Date _____

Workcenter _____

Operation # _____

Issue:

Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: _____

